

Work Order ID 109985

December-11-13 2:22:42 PM

109985

Page 1

Item ID: D3512-041

B 3512-041

B 109985

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 12/11/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/24/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MCS Date: 13-12-09 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3512	<u>RD</u> <u>11</u>
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120

0.00

120

Large Fab

Large Fab

Memo

0.00

Large Fab

1- Weld hard surface using DT8874 as per Dwg D3512 & QSI 004

A/R 2059b Hardcoat Rod M127112 → 20596

2- Weld D3512-3 spacer to D3512-1 as per dwg

A/R S.S. Rod M126048

(8) ML 13.12.17

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

(8) 13.12.17 DAS
9
9-89

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Page 2

Item ID: D3512-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 12/11/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/24/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

(8) 13-12-17DAS
9
9-89

150

Identify as per dwg & Stock Location: ST500 0.00***150***

Packaging

Memo

0.00

Packaging

8x DAS
28
9-8913-12-17

160

QC21- Final Inspection - Work Order Release 0.00

160

QC

Memo

0.00

Quality Control

DJ/Rm 13/12/18.ME
13-12-18

Picklist Print

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Work Order ID: 109985

109985

Parent Item: D3512-041

D3512-041

Parent Item Name: Wearplate Assembly

Start Date: 12/11/13

Required Date: 12/24/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP
REV:B 13.12.11 ECN13-619/ REV.D DWG DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3512-1		Manufactured	No				Each	19.0000		8			
D3512-1									**	(x8)		ml	13.12.16
Stainless Steel Wearplate													



B109999 x 8

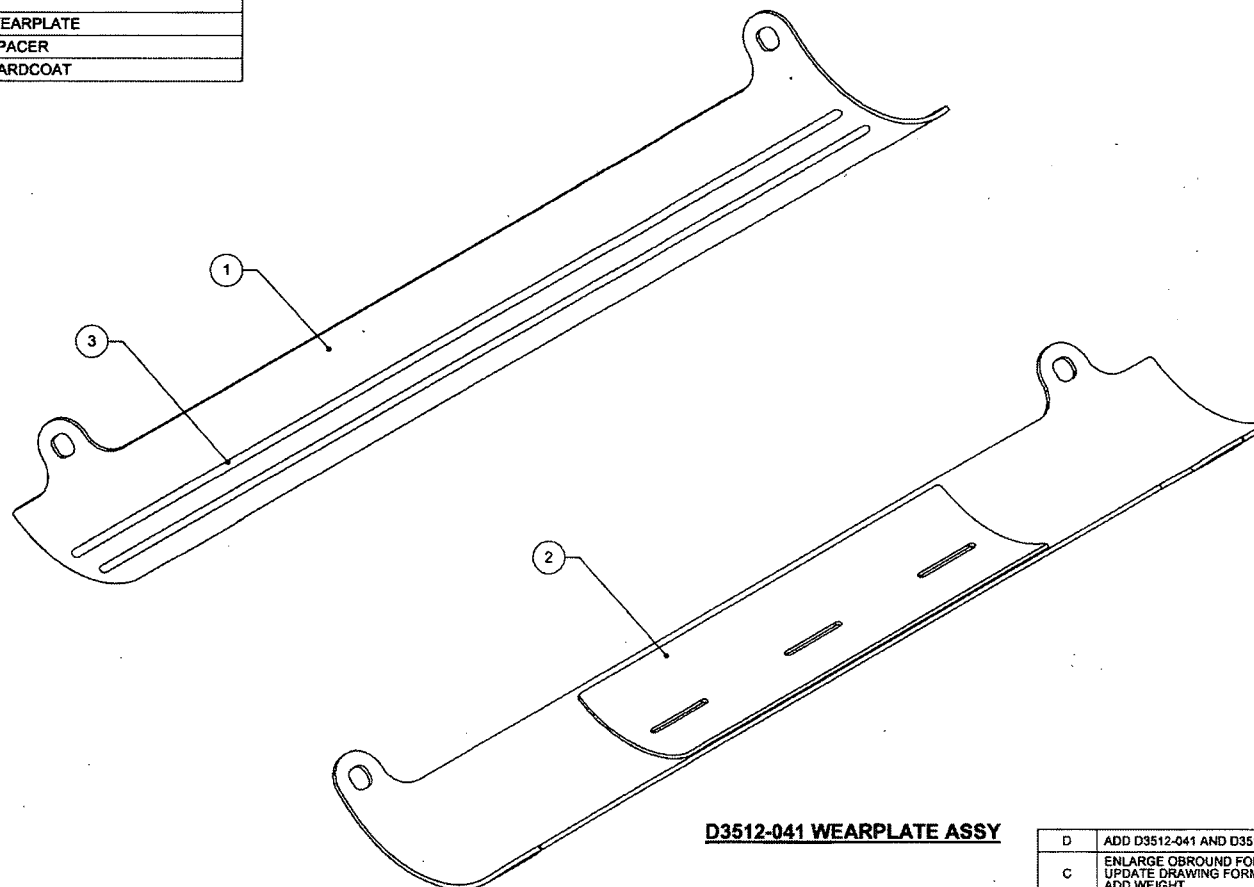
Location	Loc Qty	Loc Code
FG	2	
89154	2	
ST500	17	
106042	17	

D3512-3		Manufactured	No				Each	0.0000		8			
D3512-3									**	(x8)		ml	13.12.16
Spacer													



B109996 x 8

ITEM	QTY .041	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	2059B	HARDCOAT



109951 MCLJ
13-12-10

D3512-041 WEARPLATE ASSY

D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3512	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
DATE	13.08.28	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**SECTION A-A
SCALE 1:1.5**

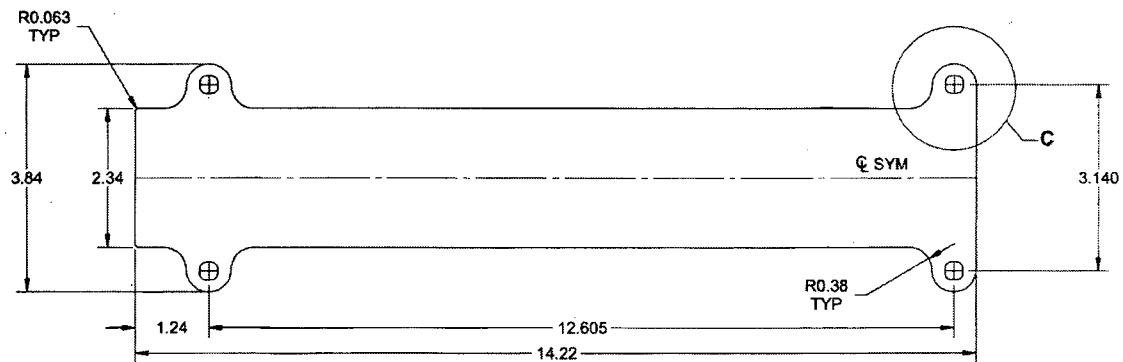
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3512-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.94 lbs
- 8) WELDING: PER QSI 004, 2059B HARDCOAT WELD 0.063 TO 0.125 THK
- 9) COAT HATCHED (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

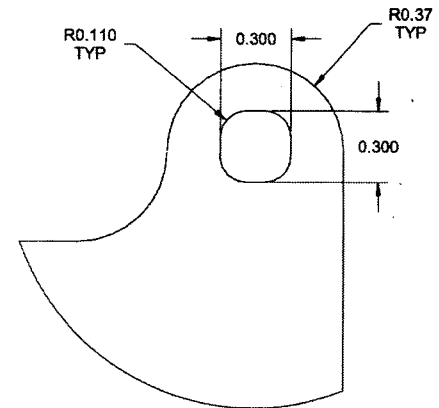
D3512-041 WEARPLATE ASSY

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3512	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D3512-1F



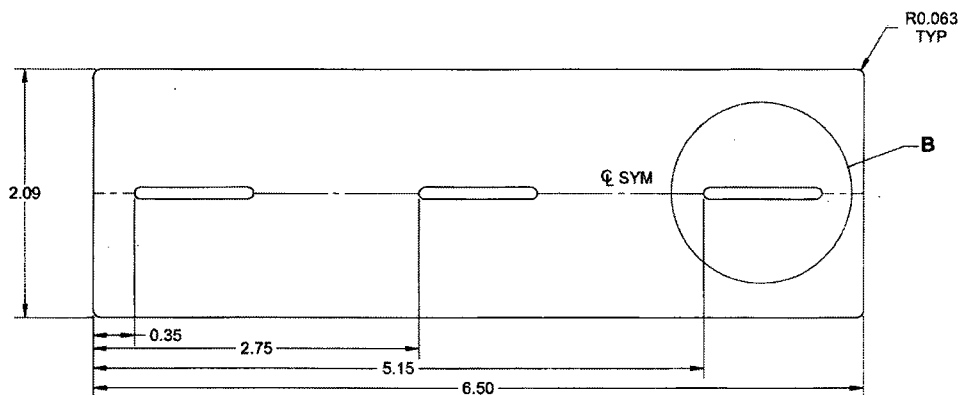
DETAIL C
SCALE 2X

NOTES:

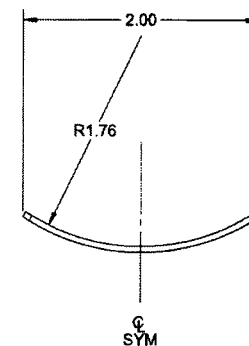
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3512	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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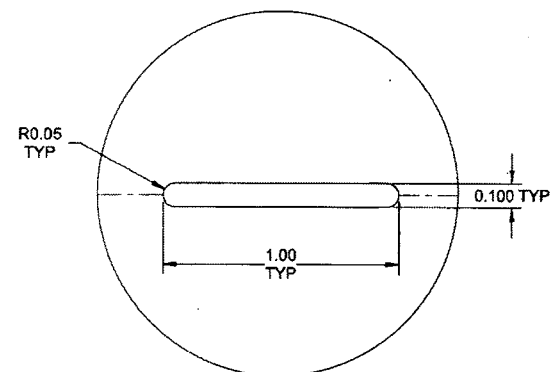
8 7 6 5 4 3 2 1



D3512-3F FLAT PATTERN



**D3512-3 SPACER
MAKE FROM D3512-3F**



**DETAIL B
SCALE 2X**

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.050 THICK (REF DART SPEC. MS304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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